BANGALORE ELECTRICITY SUPPLY COMPANY LIMITED

TECHNICAL SPECIFICATION FOR 1.1 KV 3.5 KN POLYMER PIN INSULATORS

1.0 SCOPE :

This specification covers the design, manufacture, testing and supply of 1.1KV Composite Insulators. The composite insulators shall be pin insulators for straight line locations.

2.0 STANDARDS :

Unless otherwise specified elsewhere in the specifications insulators shall confirm to the

Latest revisions of all relevant standards available at the time of placement of the order.

The insulator shall conform to the latest editions of the following standards:

- IEC 61109 – Composite insulators for overhead lines
- IEC 62217 – Polymeric insulators – General definitions, test methods and acceptance criteria
- IEC 61952 – Composite line post insulators: definitions, test methods and acceptance criteria
- IS 2486 – Insulator fittings for overhead power lines
- IS 2071 – High Voltage Testing

2.0 SYSTEM PARTICULARS:

- Nominal working voltage : 415/240 V, 3 Phase, 4 Wire
- Nominal System Voltage : 1.1 kV
- Highest system Voltage : 1.2 kV
- Frequency 50 Hz with 3% tolerance
- Number of phase 3
- Neutral earthing: effectively grounded.

3 Service condition

The LT polymeric pin insulator to be supplied shall be suitable for satisfactory continuous operation under conditions as specified below:

- Maximum ambient temperature : 50ºC
- Minimum ambient temperature : -5º C
- Relative humidity : 0 to 100%
- Average annual rainfall : ≤1000 mm
- Max. Altitude above mean see level : ≤1000 m (3300Ft)

- Isoceraunic level (Max) : ≤50 Days
- Seismic level : 0.25 g
- Max. wind speed : ≤ 39 m/s

4.0 GENERAL REQUIREMENTS

4.1 The polymer pin insulator shall consist of:

- Fiberglass Reinforced Plastic (FRP) core.
- High Temperature Vulcanized (HTV) Silicone Rubber housing and sheds.
- Hot-dip galvanized threaded metal fitting.
- One-piece moulded construction.
- UV resistant and anti-tracking material.
- Hydrophobic silicone rubber housing. Composite insulators typically use an FRP core with silicone rubber housing and galvanized fittings.

4.2 Electrical and Mechanical Characteristics

Sl.No	Particulars	Requirements
1	Type of Composite insulator	LT Pin Insulator
2	Nominal working voltage	415V/240V, 3-Phase 4 Wire
3	Nominal System Voltage kV(rms)	1.1kV
4	Highest System Voltage kV(rms)	1.2kV
5	Dry power frequency withstand voltage kV (rms) (Min)	10 kV for 1 min
6	Wet power frequency withstand voltage kV (rms) (Min)	6 kV for 1 min
7	Insulation Resistance of insulator	≥ 1000 MΩ
8	Minimum creapage distance in mm	90mm
9	Min. failing load kN	3.5 kN
10	Torsional Strength	50N-m
11	Tracking & Erosion Resistance	As per IEC 62217

4.3 **Dimensional Tolerance of Composite Insulators**

The tolerances on all dimensions e.g. diameter and length shall be allowed as follows in line with-IEC 61109:

± (0.04d+1.5) mm when d≤300mm

± (0.025d+6) mm when d>300 mm.

Where, d being the dimensions in millimeters for diameter, or length distance as the case may be.

5.0 TECHNICAL DESCRIPTION OF COMPOSITE INSULATORS

Polymeric Insulators shall be designed to meet the high quality, safety and reliability and should be capable of withstanding a wide range of environmental conditions: Polymeric Insulators shall consist of THREE parts, at least two of which are insulating Parts:- (a) Core- the internal insulating part (b) Housing- the external insulating part (c) Metal end fittings.

5.1 CORE

It shall be a glass-fiber reinforced epoxy resin rod of high strength (FRP rod). Glass fibers and resin shall be optimized in the FRP rod. Glass fibers shall be Boron free electrically corrosion resistant (ECR) glass fiber or Boron free E-Glass and shall exhibit both high electrical integrity and high resistance to acid corrosion. The matrix of the FRP rod shall be Hydrolysis resistant. The FRP rod shall be manufactured through Pultrusion process. The FRP rod shall be void free as proven through die penetration test. The FRP rod must pass electric leakage current test of 175V/mm. The leakage current shall not exceed 0.05mA.

5.2 HOUSING:

The FRP rod shall be covered by a seamless sheath of a silicone elastometric compound or silicone alloy or EVA compound of a thickness of 3mm minimum. It shall be one-piece housing using Injection Molding Principle to extrude directly onto the core and cover the core. The elastomer housing shall be designed to provide the necessary creepage distance and protection against environmental influences. Housing shall conform to the requirements of IEC 61109/92-93 with latest amendments. The bonding of the elastomeric compound to the fibre glass rod shall be perfect and shall be proved by a peel off test as described elsewhere in this specification.

5.3 WEATHERSHEDS

The composite polymer weather sheds made of a silicone elastometric compound or silicone alloy or EVA compound shall be firmly bonded to the sheath, vulcanized to the sheath or molded as part of the sheath and shall be free from imperfections. It should protect the FRP rod against environmental influences, external pollution and humidity. The weather sheds should either be of EVA or have silicon content of minimum 30% by weight. The strength of the weather shed to sheath interface shall be greater than the tearing strength of the polymer. The interface, if any, between sheds and sheath (housing) shall be free from voids.

5.4 METAL END FITTINGS (Pins):

End fitting transmit the mechanical load to the core. They shall be made of spheroidal graphite cast iron, malleable cast iron or forged steel or aluminum alloy.

They shall be connected to the rod by means of a controlled compression technique. Metal end fittings shall be hot dip galvanized after, all fittings have been completed. The material used in fittings shall be corrosion resistant. As the main duty of the end fittings is the transfer of mechanical loads to the core the fittings should be properly attached to the core by a coaxial or hexagonal compression process & should not damage the individual fibers or crack the core. The gap between fitting and sheath shall be sealed by a flexible EVA or silicone elastomeric compound or silicone alloy compound sealant. System of attachment of end fitting to the rod shall provide superior sealing performance between housing, i.e. seamless sheath and metal connection. The sealing must be moisture proof. The dimensions of end fittings of Insulators shall be in accordance with the standard dimensions stated in IEC: 60120/ IS: 2486 - Part-II /1989.

5.5 INSULATOR REQUIREMENTS:

1. FRP Rod size - 16mm
2. Weather shed thickness - 3mm
3. Weather shed Dia - 55mm-60 mm
4. Mounting Bolt & Nut size - M16
5. Total insulator length - 165mm-170mm
6. Number of weather sheds -1 No.

6.0 WORKMANSHIP

1. All the materials shall be of latest design and conform to the best engineering Practices adopted in the high voltage field. Bidders shall offer only such insulators as are guaranteed by them to be satisfactory and suitable for continued good service in power transmission/distribution lines.
2. The design, manufacturing process and material control at various stages shall be such as to give maximum working load, highest mobility, best resistance to corrosion, good finish and elimination of sharp edges and corners.
3. The design of the insulators shall be such that stresses due to expansion and contraction in any part of the insulator shall not lead to deterioration.
4. The core shall be sound and free of cracks and voids that may adversely affect the insulators.
5. Weather sheds shall be uniform in quality. They shall be clean, sound, smooth and shall be free from defects and excessive flashing at parting lines.
6. End fittings shall be free from cracks, seams, shrinks, air holes and rough edges. End fittings should be effectively sealed to prevent moisture ingress; effectiveness of sealing system must be supported by test documents. All surfaces of the metal parts shall be perfectly smooth without projecting points or irregularities, which may cause corona. All load bearing surfaces shall be sooth and uniform so as to distribute the loading stresses uniformly.
7. All ferrous parts shall be hot dip galvanized to give a minimum average coating of zinc equivalent to 610gm/sq.m. or 87 micron thickness and shall be in accordance with the requirement of IS:4759. The zinc used for galvanizing shall be of purity 99.5% as per IS:4699. The zinc coating shall be uniform, adherent, smooth, reasonably bright continuous and free from imperfections such as flux,

ash rust stains, bulky white deposits and blisters. The galvanized metal parts shall be guaranteed to withstand at least four successive dips each lasting for one (1) minute duration under the standard preece test. The galvanizing shall be carried out only after any machining.

7.0 TESTS AND STANDARDS

Insulators offered shall be manufactured with the same configuration & raw materials as used in the insulators for which design & type test reports are submitted. The manufacturer shall submit a certificate for the same. **The design & type test reports submitted should have been carried out within five years prior** to the date of opening of this tender.

7.1 DESIGN TESTS:

For polymeric insulators it is essential to carry out design test as per clause 4.1 of IEC 61109/92-93 with latest amendments. The design tests are intended to verify the suitability of the design, materials and method of manufacture (technology). When a composite insulator is submitted to the design tests, the result shall be considered valid for the whole class of insulators, which are represented by the one tested and having the following characteristics:

- Same materials for the core, and sheds and same manufacturing method;
- Same material of the fittings, the same design, the same method of attachment;
- Same or greater layer thickness of the shed material over the core (including a sheath where used);
- Same or smaller ratio of the highest system voltage to insulation length;
- Same or smaller ratio of all mechanical loads to the smallest core diameter between fittings
- Same or greater diameter of the core.

The tested composite insulators shall be identified by a drawing giving all the dimensions with the manufacturing tolerances.

Manufacturer should submit test reports for Design Tests as per IEC – 61109 (clause – 5) along with the bid. Additionally following tests shall be carried out or reports for the tests shall be submitted after award of contract:

UV test: the test shall be carried out in line with clause 7.2 of ANSI C29.13.

7.2 TYPE TESTS:

The type tests are intended to verify the main characteristics of a composite insulator. The type tests shall be applied to composite insulators, the class of which has passed the design tests.

7.2.1 Following Type test shall be conducted on a suitable number of individual insulator units, components, materials :

SL. No	Description of type test	Test procedure/standard	
1	Visual Examination		
2	Dry lightning impulse withstand voltage test	As per IEC 61109	
3	Wet power frequency test withstand voltage test	As per IEC 611 09	
4	Mechanical load-time test	As per IEC 611 09	
5	Thermal Mechanical Test	As per IEC 611 09	
6	Tracking and Erosion Test	As per IEC 611 09	
7	Recovery of Hydrophobicity test	Annexure - B	This test may be repeated every 3yrs by the manufacturer
8	Chemical composition test for silicon content	Annexure - B	Or any other test method acceptable to the owner.
9	Brittle fracture resistance test	Annexure – B	

The bidder shall submit type test reports as per IEC 61109 along with the bid. Additional type tests required if any shall be carried out by the manufacturer, after award of contract for which no additional charges shall be payable. In case, the tests have already been carried out, the manufacturer shall submit reports for the same.

7.2.2 **UV Resistance as per ASTMG 53:** 5000 Hours- UV Light for 8 hours and condensation for 4 hours in a continuous cycle. Elongation to be limited to 20% (% of elongation to break before and after the test)

7.3. Acceptance (sample) Tests

The test samples after having withstood the routine test shall be subject to the following acceptance tests in order indicated below:

(a)	Visual Inspection	IEC: 61109
(b)	Verification of dimensions	Clause 7.2 IEC: 61109,
(c)	Galvanizing test	IS:2633/15: 6745
(e)	Verification of the specified mechanical load	Clause 7.4IEC: 61109,

7.4 Routine Tests

Sl No	Description	Standard
1	Identification of marking and dimensional verification	As per IEC: 61109
2	Visual Inspection	As per IEC:61109
3	Mechanical Routine test	As per IEC:61106

Every Polymeric Insulator shall withstand Mechanical Routine test at ambient temperature, Tensile Load at RTL corresponding to atleast 50% of the SML for atleast 10

7.5 The following characteristics shall be met by FRP rods used in manufacture of the insulator:

1. Tensile strength: 760 N/mm² Min
2. Glass content (%) : 75% min
3. Tg by DSC – 110 Deg C min
4. Dye penetration – No dye rise on 10 sample of 10 mm thick> 15 mins
5. Water diffusion & Voltage tests – 100 hours – 12kv for 1 min, no puncture or flashover on the FRP & current shall not exceed 1 mA
6. Hardness> 51 Barcol No
7. ECR glass – Boron/alkali content not more than 0.8%.

8.0 QUALITY ASSURANCE PLAN :

8.1 The bidder shall submit following information along with the bid:

i. Test certificates of the raw materials and bought out accessories.

ii. Statement giving list of important raw material, their grades along with names of Sub suppliers for raw materials, list of standards according to which the raw materials are tested. List of tests normally carried out on raw materials in the presence of bidder's representative.

iii. List of manufacturing facilities available.

iv. Level of automation achieved and lists of areas where manual processing exists.

v. List of areas in manufacturing process, where stage inspections are normally carried out for quality control and details of such tests and inspections.

vi. List of testing equipments available with the bidder for final testing of equipment along with valid calibration reports.

vii. The manufacturer shall submit Manufacturing Quality Assurance Plan (QAP) followed during manufacture and testing.

8.2 The successful bidder shall submit the routine test certificates of bought out raw materials/accessories and central excise passes for raw material at the time of inspection.

8.3 The Purchaser representative shall at all times be entitled to have access to the works and all places of manufacture, where insulator, and its component parts shall be manufactured and the representatives shall have full facilities for unrestricted inspection of the Supplier's and sub-Supplier's works, raw materials, manufacture of the material and for conducting necessary test as detailed herein.

8.4 The material for final inspection shall be offered by the Supplier only under packed condition. The owner shall select samples at random from the packed lot for carrying out acceptance tests. The lot offered for inspection shall be homogeneous and shall contain insulators manufactured in 3-4 consecutive weeks.

8.5 The Supplier shall keep the Owner informed in advance of the time of starting and the progress of manufacture of material in their various stages so that arrangements could be made for inspection.

8.6 No material shall be dispatched from its point of manufacture before it has been satisfactorily inspected and tested unless the owner in writing waives off the inspection. In the later case also the material shall be dispatched only after satisfactory testing specified herein has been completed.

8.7 The acceptance of any quantity of material shall in no way relieve the Supplier of his responsibility for meeting all the requirements of the specification and shall not prevent subsequent rejection, if such materials are later found to be defective.

9.0 TEST CERTIFICATE :

The tenderer shall furnish detailed type test reports of the offered composite Insulators at the NABL approved laboratories to prove that the composite Insulators offered meet the requirements of the specification. These Type Tests should have been carried out within five years prior to the date of opening of this tender.

10.0 TESTING FACILITIES :

The tenderer must clearly indicate what testing facilities are available in the works of the manufacturer and whether facilities are adequate to carry out all Routine & acceptance Tests. These facilities should be available to Purchasers Engineers if deputed to carry out or witness the tests in the manufacturer works. If any test cannot be carried out at the manufacturer's work, the reasons should be clearly stated in the tender. The insulators shall be tested in accordance with the procedure detailed in IEC 61109 / 92-93 with latest amendments.

11.0. DRAWINGS AND APPROVALS:

The insulator shall be as per the Drawing enclosed for reference the successful bidder shall obtain GTP & Drawing approval from QS&S section Before mass production

12.0 RETEST AND REJECTION:

12.1 Sample Procedure for testing of insulators shall be as per clause 7.1 to 7.6 of IEC 61109 for Acceptance & Routine Tests. For the sampling tests, two samples are used, E1and E2. The sizes of these samples are indicated in the table below.

Lot Size(N)	Sample size	
	E1	E2
N<300	Subject to agreement	
300<N<2000	4	3
2000<N<5000	8	4
5000<N<10000	12	6

If more than 10000 insulators are concerned, they shall be divided into an optimum number of lots comprising between 2000 and 10000 insulators. The results of the tests shall be evaluated separately for each lot. The insulators shall be selected by the purchaser's representative from the lot at random. The samples shall be subjected to the applicable sampling tests.

The sampling tests are:

Verification of dimensions	- (E1 + E2)
Verification of the locking system	- (E2)
Verification of tightness of the interface between end fittings & Insulator housing	- (E2)
Verification of the specified mechanical load SML	- (E1)
Galvanizing test	- (E2)

In the event of a failure of the sample to satisfy a test, the retesting procedure shall be as follows :

- If only one insulator or metal part fails to comply with the sampling tests, a new sample equal to twice the quantity originally submitted to the tests shall be subjected to retesting. The retesting shall comprise the test in which failure occurs.
- If two or more insulator or metal parts fail to comply with any of the sampling tests or if any failure occurs during the retesting, the complete lot is considered as not complying with this standard and shall be withdrawn by the manufacturer.
- Provided the cause of the failure can be clearly identified, the manufacturer may sort the lot to eliminate all the insulators with these defects. The sorted lot then be resubmitted for testing. The number then selected shall be three times the first chosen quantity for tests. If any insulators fail during this retesting, the complete lot is considered as not complying with this standard and shall be withdrawn by the manufacturer.

12.2 Verification of dimensions (E1 + E2)

The dimensions given in the drawings shall be verified. The tolerances given in the drawing are valid. If no tolerances are given in the drawings the values mentioned in this specification shall hold good.

12.3 Verification of the locking system (E2)

This test applies only to the insulators equipped with socket coupling as specified by IEC 120 and is performed according to IEC 383.

12.4 Verification of tightness of the interface between end fittings & Insulator housing (E2)

One insulator selected randomly from the sample E2, shall be subjected to crack indication by dye penetration, in accordance with ISO 3452,on the housing in the zone embracing the complete length of the interface between the housing and metal fitting and including an additional area, sufficiently extended beyond the end of the metal part. The indication shall be performed in the following way.

Some housing materials may be penetrated by the penetrant. In such cases evidence shall be provided to validate the interpretation of the results. After the 1 min. test at 70 % of the SML, if any cracks occur, the housing and, if necessary, the metal fittings and the core shall be cut, perpendicularly to the crack in the middle of the widest of the indicated cracks, into two halves. The surface of the two halves shall then be investigated for the depth of the cracks.

12.6 GALVANIZING TEST

This test shall be performed according to IS: 2633/IS: 6745 on galvanized parts.

13.0 MARKINGS:

Each insulator shall be legibly and indelibly marked with the following details as per IEC- 61109:

a) Name or trademark of the manufacturer.
b) Voltage & Type
c) BESCOM
c) Month and year of manufacturing.
d) Min. failing load/guaranteed mechanical strength in kilo Newton followed by the word 'KN' to facilitate easy identification.
e) Country of Manufacturer.

14.0 PACKING :

1. All insulators shall be packed in strong corrugated box of min. 7 ply duly paletted or wooden crates. The gross weight of the crates along with the material shall not normally exceed 100 Kg to avoid hackling problem. The crates shall be suitable for outdoor storage under wet climate during rainy season. The following shall be marked on the packing
   - Marking on the Manufacturer's name/trademark
   - Year of manufacture
   - "BESCOM"
   - Batch number
   - Rated voltage
   - Purchase Order number
2. The packing shall be of sufficient strength to withstand rough handling during transit, storage at site and subsequent handling in the field.
3. Suitable cushioning, protective padding, or Dunn age or spacers shall be provided to prevent damage or deformation during transit and handling.
4. All packing cases shall be marked legibly and correctly so as to ensure safe arrival at their destination and to avoid the possibility of goods being lost or wrongly dispatched on account of faulty packing and faulty or illegible markings. Each wooden case /crate /corrugated box shall have all the markings stenciled on it in indelible ink.

5. The bidder shall provide instructions regarding handling and storage precautions to be taken at site.

General Manager (Ele)
Quality, Standard & Safety

Annexure-A

STANDARDS TO BE ADOPTED FOR COMPLETE INSULATORS

Sl No	IS Standard	Title	International Standard
1		Definition. test methods and acceptance criteria for composite insulators for a.c. overhead lines above 1000 V	IEC: 61109
2	IS: 731	Porcelain insulators for overhead Power lines with a nominal voltage greater than 1000 V	IEC: 60383
3	IS: 2071	Methods of High Voltage Testing	IEC: 60060-1
4	IS: 2486	Specification for Insulator fittings for Overhead Power Lines with a nominal Voltage greater than 1000V General Requirements and Tests Dimensional Requirements Locking Devices	IEC: 60120 IEC: 60372
5		Thermal Mechanical Performance test and mechanical performance test on string insulator units	IEC: 60575
6	IS: 13134	Guide for the selection *of* insulators in respect *of* polluted Conditions	IEC: 60815
7		Characteristics *of* string insulator units *of* the long rod type	IEC: 60433
8		Hydrophobicity Classification Guide	STRI Guide 1.92/1
9		Radio interference characteristics *of* overhead power lines and high-voltage equipment.	CISPR:18-2 Part-2
10	IS: 8263	Methods *of* RI *Test of* HV insulators	IEC: 60437
11		Standard for Insulators Composite-Distribution Dead-end Type	ANSI C29. 13-2000
12	IS: 4759	Hot dip zinc coatings on structural steel & other allied products	ISO:1459 ISO:1461
13	IS:2629	Recommended Practice for Hot. Dip . Galvanisation *for* iron and steel	ISO:1461(E)
14	IS: 6745	Determination *of* Weight *of* Zinc Coating on Zinc coated iron and steel articles	ISO:1460
15	IS:3203	Methods *of* testing of local thickness *of* electroplated coatings	ISO:2173
16	IS:2633	Testing *of* Uniformity *of* Coating *of* zinc coated articles	
17		Standard specification *for* glass fiber strands	ASTM D 578-05
18		Standard test method *for* compositional analysis	ASTM E 1131-03

		by Thermogravimetry	
19	IS: 4699	Specification for refined secondary Zinc	

Annexure-B

Guaranteed Technical Particulars of 1.1KV Polymer pin insulators to be submitted along with bid			
Sl. No	**Description**	**Unit**	**Bidders Offer**
1	Type of insulator		
2	Standard according to which the insulators manufactured and tested		
3	Name of material used in manufacture of the insulator with class/grade		
a	Material of Core(FRP Rod)		
	i) E-glass or ECR - glass		
	ii) Boron Content		
b	Material of housing & whethersheds(Silicon content by weight)		
c	Material of end fittings		
d	Sealing compound for end fittings		
4	Colour		
5	Electrical Characteristics:		
a	Nominal System Voltage	kV(rms)	
b	Highest System Voltage	kV(rms)	
c	Dry Power frequency withstand voltage	kV(rms)	
d	Wet Power frequency withstand voltage	kV(rms)	
e	Creepage Distance(Min)	mm	
6	Mechanical Characteristics:		
a	Minimum failing load	kN	
7	Dimensions of insulator		
i	Weight	Kg.	
ii	Dia. Of FRP Rod	mm	
iii	Length of FRP Rod	mm	
iv	Dia. Of whether sheds	mm	
v	Thickness of housing	mm	
vi	Dry arc distance	mm	
vii	Bottom fitting Threading length		
viii	Dimensional drawing of insulator (including weight with tolerances in weight) enclosed.	Yes/No	

8	Method of fixing of sheds to housing (specify:) : Single mould or Modular construction(injection moulding/compression moulding)		
9	No. of weather sheds		
10	Section length		
11	Type of sheds		
i	Aerodynamic		
ii	With underribs		
12	Packing details		
a	Type of packing		
b	No. of insulators in each pack		
c	Gross weight of package		
13	Any other particulars which the bidder may like to give		

Manufacturer seal and Signature